

Work Order ID 60596

Thursday, July 15, 2010 10:19:49 AM



Page 1

Item ID: D206-642-311

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube LH

Start Date: 7/15/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 7/22/2010 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: RS Date: 10-7-15 Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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D206-642	Rev N
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100		0.00
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DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-642-311 CHG006

8/10/13/30

for BG 10/07/22

110	Pick Kit	0.00
-----	----------	------



Packaging

Memo

0.00

Packaging

10-7-25 SP

120	QC4- 100% Inspect kits for completeness	0.00
-----	---	------



QC

Memo

0.00

Quality Control

8/10/13/30

AD

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60596

Thursday, July 15, 2010 10:19:49 AM



Page 2

Item ID: D206-642-311

Accept



Setup Start



Revision ID:

Item Name: Skidtube LH

Stop



Start Date: 7/15/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 7/22/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Packaging

Packaging

0.00

Memo

0.00

Identify and pack for shipping as per PPP D206-642-311

Location: STF

PPP Rev: _____

10/7/30 SL

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/07/30 JF

D206-729

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 60596

Parent Item: D206-642-311

Parent Item Name: Skidtube LH

Start Date: 7/15/2010

Required Date: 7/22/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:J 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM/EC
IPP Rev:K 07-12-04 ECN 1080p DD verified by:ec
IPP Rev:L 08-09-29 as per DSI9421 DD verified by:EC IPP Rev:M
as per REV.N DD 10.04.19 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
5 D206-642-341 Replacement Skidtube		Manufactured	No			110	Each	3.0000	1	1			
<div> <div>Location</div> <div>FG081</div> <div>36550</div> <div>44043</div> <div>44044</div> </div> <div> <div>Loc Qty</div> <div>3</div> <div>1</div> <div>1</div> <div>1</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> <div></div> </div>													
6 D206-648-013 GHW Modification	CHG002	Manufactured	No			110	Each	1.0000	1	1			
<div> <div>Location</div> <div>FG120</div> <div>59234</div> </div> <div> <div>Loc Qty</div> <div>1</div> <div>1</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
6 D2932-1 Saddle LH Out, 206		Manufactured	No			110	Each	8.0000	1	1			
<div> <div>Location</div> <div>ST421</div> <div>52590</div> <div>53327</div> <div>ST428</div> <div>59936</div> </div> <div> <div>Loc Qty</div> <div>4</div> <div>1</div> <div>3</div> <div>4</div> <div>4</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> <div></div> <div></div> </div>													

B60411 10/7/20 SP

10-7-20 SP

10-7-20 SP

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 2

Work Order ID: 60596

Parent Item: D206-642-311

Parent Item Name: Skidtube LH

D2933-1



Saddle LH In, 206

Manufactured No

110 Each

7.0000

Start Date: 7/15/2010

Required Date: 7/22/2010

Start Qty: 1.00

Required Qty: 1.00



10-7-20

S

Location

Loc Qty

Loc Code

ST421

3

53328

3

ST428

4

59937

4

D2938-1



Saddle LH Out, 206

Manufactured No

110 Each

5.0000



10-7-20

Location

Loc Qty

Loc Code

ST421

3

53331

3

ST428A

2

58532

2

D2939-1



Saddle LH In, 206

Manufactured No

110 Each

9.0000



10-7-20

Location

Loc Qty

Loc Code

ST421

3

53333

3

ST428A

6

58267

2

58534

4

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Page 2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 3

Work Order ID: 60596

Parent Item: D206-642-311

Parent Item Name: Skidtube LH

Start Date: 7/15/2010

Required Date: 7/22/2010

Start Qty: 1.00

Required Qty: 1.00

AN3-41A

Purchased

No

110

Each

332.0000

8

8

Bolt

Location

Loc Qty

Loc Code

ST354

332

112431

32

114382

50

114522

50

114941

200

D2652

Manufactured

No

110

Each

249.0000

16

16

Bushing

Location

Loc Qty

Loc Code

FG

44

31985

44

ST021

205

58176

42

59109

163

MS21042L3

Purchased

No

110

Each

2,684.000

8

18

Nut

Location

Loc Qty

Loc Code

ST300

2684

112385

4

114523

204

114718

476

114784

2000

AN960JD10

NAS1149D0363J

Purchased

No

110

Each

0.0000

8

8

Washer

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Page 3

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DCA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

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Work Order ID: 60596

Parent Item: D206-642-311

Parent Item Name: Skidtube LH



Start Date: 7/15/2010

Required Date: 7/22/2010

Start Qty: 1.00

Required Qty: 1.00

AN5-10A Purchased No 110 Each 215.0000 4 4
Bolt

Location	Loc Qty
ST337	215
114199	15
114752	100
115108	100

Loc Code



M107013 10.7.26

AN5-11A Purchased No 110 Each 69.0000 4 4
Bolt

Location	Loc Qty
ST337	69
112314	39
115016	30

Loc Code



M109545 10.7.26

AN960JD516 NAS1149D0563J Purchased No 110 Each 0.0000 8 8
Washer

AN4-6A Purchased No 110 Each 1,260.000 12 12
Bolt

Location	Loc Qty
ST356	1260
112933	96
113149	361
114523	2
114615	1
114941	500
115108	300

Loc Code



M11752 10.7.26



10.7.26

AN960JD416 NAS1149D0463J Purchased No 110 Each 0.0000 25 25
Washer



M115000 10.7.26

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Page 4

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

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Work Order ID: 60596

Parent Item: D206-642-311

Parent Item Name: Skidtube LH

Start Date: 7/15/2010

Required Date: 7/22/2010

Start Qty: 1.00

Required Qty: 1.00

MS21042L4

Purchased No

110 Each

4,191.000

12 12



Nut

Location

Loc Qty

Loc Code

ST300

4191

113422

68

114523

28

114718

95

114784

2000

115108

2000

10-7-26

D3407-043

Manufactured No

110 Each

38.0000



Tow Ring

Location

Loc Qty

Loc Code

ST464

38

50176

6

50387

20

53351

12

10-7-26

D3456-1

Manufactured No

110 Each

56.0000



Washer

Location

Loc Qty

Loc Code

ST058

56

54692

56

10-7-26

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Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

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Work Order ID: 60596

Parent Item: D206-642-311

Parent Item Name: Skidtube LH

Start Date: 7/15/2010

Required Date: 7/22/2010

Start Qty: 1.00

Required Qty: 1.00

D3457-1

Manufactured No

110

Each

63.0000

2 2



Washer

Location

Loc Qty

Loc Code

FG

10

32409

10

ST059

53

45913

2

52981

51

MS21043-4

Purchased No

110

Each

1,283.000

1 1



Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

1243

112492

25

113069

8

114348

410

114523

500

114784

300

AN4C5A

Purchased No

110

Each

513.0000

1 1



BOLT

Location

Loc Qty

Loc Code

ST346

513

110552

13

112243

500

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Page 6

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

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Picklist Print

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Page 7

Work Order ID: 60596



Parent Item: D206-642-311



Parent Item Name: Skidtube LH

Start Date: 7/15/2010

Required Date: 7/22/2010

Start Qty: 1.00

Required Qty: 1.00

AN960C416 NAS1149C0463 Purchased No 110 Each

113.0000 1 1



washer



10.7.208

Location

Loc Qty

Loc Code

ST346

113

100993

113

D3413-1

Manufactured No

110 Each

31.0000 1 1



Ring



10.7.208

Location

Loc Qty

Loc Code

ST473

31

51586

1

53446

23

58524

7

D2712

Manufactured No

110 Each

193.0000 10 10



Set Screw



B34628 10.7.208

Location

Loc Qty

Loc Code

FG

50

29962

50

ST022

143

16400

20

50415

123

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

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Work Order ID: 60596



Parent Item: D206-642-311



Parent Item Name: Skidtube LH

Start Date: 7/15/2010

Required Date: 7/22/2010

Start Qty: 1.00

Required Qty: 1.00

D2934

Manufactured No

110 Each

70.0000

2

2



Saddle Spacer



10.7.26

SP

Location

Loc Qty

Loc Code

FG

6

31929

6

ST031

64

59641

64

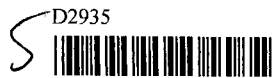
Manufactured No

110 Each

56.0000

2

2



D2935

Saddle Spacer



10.7.26

SP

Location

Loc Qty

Loc Code

ST028

45

59642

45

ST031

11

50211

11

2

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DCA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

4.5 206 L/L-1/L-3/L-4/407 LOW & HIGH GEAR SKIDTUBES

Item	Qty -311	Qty -312	Qty -341	Qty -347	Qty -013	Part Number	Description
	X					D206-642-311	SKIDTUBE INSTALLATION, LH
		X				D206-642-312	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-341	SKIDTUBE
				X		D206-642-347	WEARSHOE KIT (REPLACES -343)
	1	1			X	D206-648-013	GROUND HANDLING KIT
1			1			D2650-5	SKIDTUBE ASSEMBLY
2A			14			D2651-1	* PLUG ⁽¹⁾
2B			14			D2651-3	* O-RING ⁽¹⁾
3			1			D2646	* AFT CAP ⁽¹⁾
4			2			MS27039-1-08	* SCREW ⁽¹⁾
5			2			AN960JD10L	* WASHER ⁽¹⁾
6	1					D2932-1	SADDLE, FWD OUT, LH
6		1				D2932-2	SADDLE, FWD OUT, RH
7	1					D2933-1	SADDLE, FWD IN, LH
7		1				D2933-2	SADDLE, FWD IN, RH
8	1					D2938-1	SADDLE, AFT OUT, LH
8		1				D2938-2	SADDLE, AFT OUT, RH
9	1					D2939-1	SADDLE, AFT IN, LH
9		1				D2939-2	SADDLE, AFT IN, RH
10	8	8				AN3-41A	BOLT
11	16	16				D2652	BUSHING
12A	8	8				MS21042-3	NUT (OR MS21042L3)
12B	8	8				AN960JD10	WASHER
13	4	4				AN5-10A (OR AN5-11A)	* BOLT ⁽²⁾
14	4	4				AN5-11A (OR AN5-12A)	* BOLT ⁽²⁾
15	8	8				AN960JD516	WASHER
16	12	12				AN4-6A	BOLT
17	24	24				AN960JD416	WASHER
18	12	12				MS21042-4	NUT (OR MS21042L4)
20A			6	6		D3537-1	WEARPAD (REPLACES D2648-3)
21A			1	1		D3537-3	WEARPAD (REPLACES D3429-1)
22A			1	1		D3535-11	WEARSHOE (REPLACES D2656-11)
22B			1	1		D3536-11	GASKET
23A			1	1		D3535-23	WEARSHOE (REPLACES D2656-23)
23B			1	1		D3536-23	GASKET
24A			1	1		D3535-35	WEARSHOE (REPLACES D2656-35)
24B			1	1		D3536-35	GASKET
26A			54	54		MS27039C1-08	SCREW
26B			54	54		AN960C10L	WASHER
26C			54			ALS7-1032-130	* INSERT ⁽¹⁾ (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1				D3407-043	TOW RING ASSEMBLY (REPLACES D2968-043)
31	1	1				D3456-1	WASHER
32	1	1				D3457-1	WASHER
33	1	1				MS21043-4	NUT
34	1	1				AN4C5A	BOLT
35	1	1				AN960C416	WASHER
36	1	1				D3413-1	RING (REPLACES D2655)
37	10	10				D2712	SET SCREW
38	2	2				D2934	SADDLE SPACER
39	2	2				D2935	SADDLE SPACER
40					2	D3414-041	GHW LUG (REPLACES D2659)
41					4	AN3C37A	BOLT
42					8	D2652	BUSHING
43					4	MS21043-3	NUT
44					4	AN960C10	WASHER

NOTES: ⁽¹⁾ DENOTES THAT PART IS INCLUDED WITH D2650-5 ASSEMBLY ABOVE⁽²⁾ CHOICE OF BOLT WILL DEPEND ON CROSSTUBE (SEE INSTALLATION PROCEDURE)

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Revision: N

Date: 09.09.09